

5430.1 DeRev

Work Order ID 53724

November 13, 2009 1:17:55 PM



Page 1

Item ID: D350-591-133

Accept



Setup Start



Revision ID: B

Item Name: Aft Maintenance Step

Stop



Start Date: 11/13/09 Start Qty: 5.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2946

Rev B

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile and type labels as per PPP D350-591-133 CHG003

8/29/12/02

AG BG 09/11/17

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

Aug 11.16

2-Deburr

Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.

S

Work Order ID 53724

November 13, 2009 1:17:55 PM

Page 2

Item ID: D350-591-133

Accept

Setup Start

Revision ID: B

Stop

Item Name: Aft Maintenance Step

Start Date: 11/13/09 Start Qty: 5.00

Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
130 Large Fab Large Fab	Large Fab Memo 1-Deburr and Bevel ends for welding 2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946 A/RAluminum Rod 3-Grind End Cap welds flush	0.00 0.00							
140 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							

2) Sorlu

5

11-11-18

5

5 11-11-18

Work Order ID 53724

November 13, 2009 1:18:14 PM



Page 3

Item ID: D350-591-133

Accept



Setup Start



Revision ID: B

Stop



Item Name: Aft Maintenance Step

Start Date: 11/13/09 Start Qty: 5.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 5.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(X) 5	1		
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				5	1		
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				(5X) 5	1		

27 09/11/18

12 09.11.18

7 m-k 09/11/18

Work Order ID 53724

November 13, 2009 1:18:15 PM



Page 4

Item ID: D350,591-133

Accept



Setup Start



Revision ID: B

Stop



Item Name: Aft Maintenance Step

Start Date: 11/13/09 Start Qty: 5.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 5.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Large Fab	Large Fab	0.00				5	0		
Large Fab	Memo Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush. A/R AL ROD BATCH: <u>M111311</u>	0.00							
190 QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00				5	0		BE 09/11/19
Quality Control	Memo	0.00							
200 QC	QC5- Inspect part completeness to step on W/O	0.00				25	0		
Quality Control	Memo ⇒ Sorlulig	0.00							

Work Order ID 53724

November 13, 2009 1:18:20 PM

Page 5

Item ID: D350-591-133
Revision ID: B
Item Name: Aft Maintenance Step

Accept

Setup Start

Stop

Start Date: 11/13/09 Start Qty: 5.00
Required Date: 11/20/09 Req'd Qty: 5.00




Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	⇒ JH 09/11/23			(X5)	Ø		
220  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M112148 Memo START TIME: 7:00am OVEN TEMPERATURE: 320°F FINISH TIME: 7:30am	0.00 0.00	⇒ JH 09/11/24			X5	Ø		
230  HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch M112623 Memo	0.00 0.00	⇒ M-H 09/11/24			(5X)	Ø		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53724

November 13, 2009 1:18:20 PM



Page 6

Item ID: D350-591-133

Accept



Setup Start



Revision ID: B

Stop



Item Name: Aft Maintenance Step

Start Date: 11/13/09 Start Qty: 5.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 5.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

QC3- Inspect Part Finish

0.00

BR 09-11-24

(5)



QC

Memo

0.00

Quality Control

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/12/25

sl

sl

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

=> S 09/12/07

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 53724

November 13, 2009 1:18:25 PM



Page 7

Item ID: D350-591-133

Accept



Setup Start



Revision ID: B

Stop



Item Name: Aft Maintenance Step

Start Date: 11/13/09 Start Qty: 5.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270



Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-133

Location: 62

PPP Rev: D

9/12/07

SD SD

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/12/08

MF 09-12-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 13, 2009 1:17:51 PM

Page 1

Work Order ID: 53724

Parent Item: D350-591-133RevB

Parent Item Name: Aft Maintenance Step

Comments:

Start Date: 11/13/09

Required Date: 11/20/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2622-120CRevC1

Manufactured

No

110

Each

139.9200

2.6000



Step Extrusion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

139.92

48612

30.92

52026

109

D2734RevC

Manufactured

No

130

Each

49.0000

10.0000



Step End Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

49

43535

2

48110

47

D2944RevA

Manufactured

No

130

Each

8.0000

10.0000



Step Mounting Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53725

8

29351

3

36407

5

09.11.16

5
09.11.16

10
09.11.16

3
7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

November 13, 2009 1:17:51 PM

Page 2

Work Order ID: 53724

Parent Item: D350-591-133RevB

Parent Item Name: Aft Maintenance Step

Comments:

Start Date: 11/13/09

Required Date: 11/20/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-11A 4x

Purchased

No

250

Each

606.0000

20.0000



Bolt

9/16/05

SD

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

606

110382

562

8170

4

8942

40

AN4-14A 8x

Purchased

No

250

Each

148.0000

40.0000



Bolt

12x

4x

4x SD

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

148

107534

19

10372

129

AN4-16A 8x

Purchased

No

250

Each

304.0000

40.0000



Bolt

9/12/04 SD

23x 11.3359

17 SD

9/16/05 SD SD

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

304

112641

8

112969

296

40x SD

November 13, 2009 1:17:52 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 13, 2009 1:17:52 PM

Page 3

Work Order ID: 53724

Parent Item: D350-591-133RevB

Parent Item Name: Aft Maintenance Step

Start Date: 11/13/09

Required Date: 11/20/09

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-7A 2x

Purchased

No

250

Each

211.0000

10.0000

Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

211

112794

111

112933

100

AN960JD416 14x

Purchased

No

250

Each

3,939.000

70.0000

Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3939

108161

329

110523

340

111279

101

111916

482

112314

2687

16941

0

M113226 9/11/25 SP

9/11/25 SP

70x50

November 13, 2009 1:17:52 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval* Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 13, 2009 1:17:52 PM

Page 4

Work Order ID: 53724

Parent Item: D350-591-133RevB

Parent Item Name: Aft Maintenance Step

Comments:

Start Date: 11/13/09

Required Date: 11/20/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2230-1RevG 4X		Manufactured	No			250	Each	137.0000	20.0000			
----------------	--	--------------	----	--	--	-----	------	----------	---------	--	--	--

Lug

9 lubes sp

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Main Warehouse

FG

137

51566

137

D2230-3RevG 4X		Manufactured	No			250	Each	169.0000	20.0000			
----------------	--	--------------	----	--	--	-----	------	----------	---------	--	--	--

Lug

20x36

9 lubes sp (5X)

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Main Warehouse

ST

3

51568

3

Main Warehouse

ST176

166

51428

166

D2732-030RevB1		Manufactured	No			250	Each	0.0000	40.0000			
----------------	--	--------------	----	--	--	-----	------	--------	---------	--	--	--

Rubber Cushion
(8X) 3.00" per DSI 9459 revB

20x36

34318 9/11/25 SP

PRG 1/2 PM

November 13, 2009 1:17:52 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 13, 2009 1:17:53 PM

Work Order ID: 53724

Parent Item: D350-591-133RevB

Parent Item Name: Aft Maintenance Step

Comments:

Start Date: 11/13/09

Required Date: 11/20/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2856-400RevA 1.20 Manufactured

No

250

f

360.0237

6.3000



Abraison Strip

9/16/25 *sl*
52

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST403

360.0236842

50593

144.023684

52563

216

3x51

(2X) 4.00" X 7.20" per dwg - measure & qty

D2945RevA 1.20 Manufactured

No

250

Each

9.0000

5.0000



Step Mounting Plate

✓

51680 9/14/25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

9

51680

9

51680

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 13, 2009 1:17:53 PM

Page 6

Work Order ID: 53724

Parent Item: D350-591-133RevB

Parent Item Name: Aft Maintenance Step

Comments:

Start Date: 11/13/09

Required Date: 11/20/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042E4 Nut		Purchased	No			250	Each	5,412.000	70.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5412	
110507	184	
111827	5221	
112314	7	
15924	0	

91165 (SV) sf

70X50

November 13, 2009 1:17:53 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Reason: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/0 53724

DART

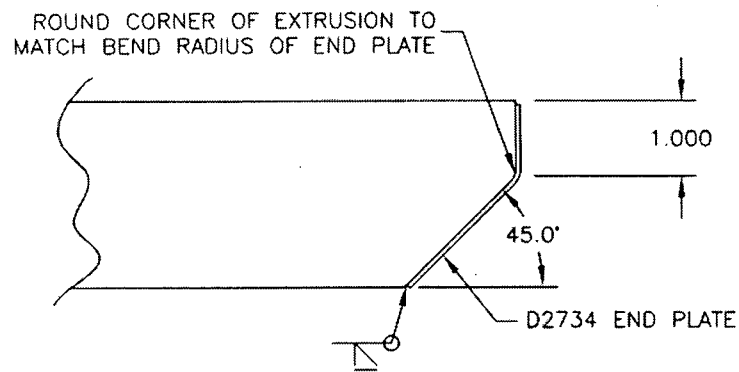
D2946 STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2946	Step Assembly	X
D2622-63	STEP EXTRUSION*	1
D2734	END PLATE	2
D2944	STEP MOUNTING PLATE	2

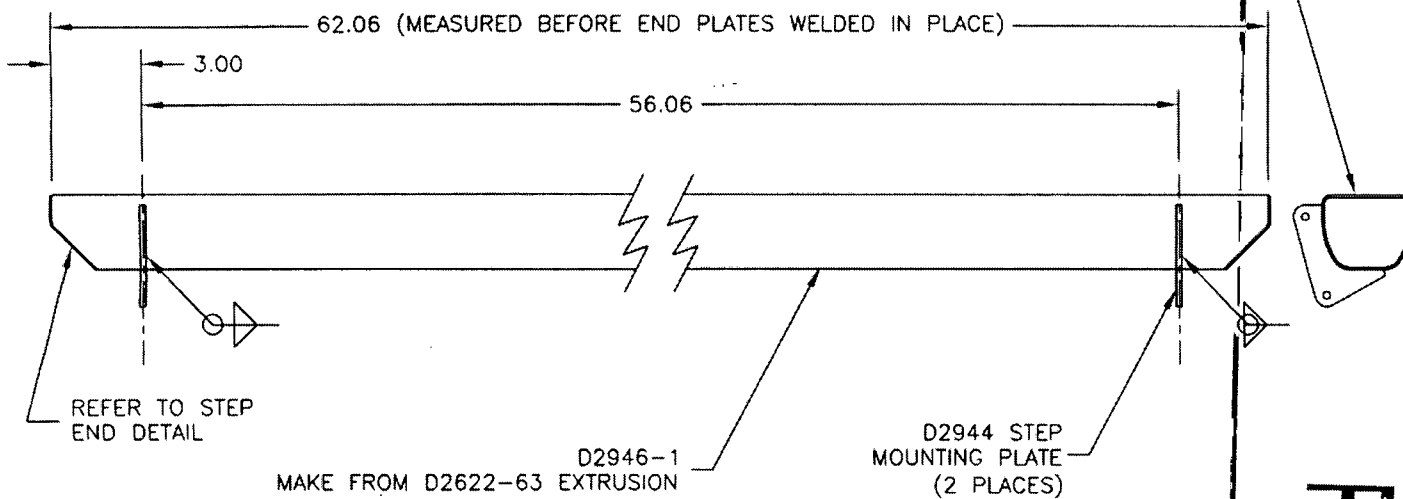
*cut per drawing

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



TYPICAL STEP END DETAIL
NOT TO SCALE



D2946-041 STEP ASSEMBLY

D2946 STEP ASSEMBLY

- 1) MAKE FROM D2622 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	PH	HAWESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
05.11.14	05.11.14	D2946
DATE		TITLE
		STEP ASSEMBLY
A	99.12.13	NEW ISSUE
B	05.11.14	UPDATE FINISHING NOTE
		REV. B
		SHEET 1 OF 1
		SCALE
		1:6

RELEASED
05.11.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<i>Heli-Access-Step</i> ™, Long Step – High Skid
	X					D350-591-113	<i>Heli-Access-Step</i> ™, Short Step – High Skid
		X				D350-591-115	<i>Heli-Access-Step</i> ™, Short Step – Low Skid
			X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
				X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
					X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4	4	4		AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

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Revision: G

Date: 08.10.06

REFERENCE ONLY

8

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6

REF FAA STC: SH967NE

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying crosstube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -121	Qty -122	Qty -123	Qty -124	Qty -133	Part Number	Description
X					D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X				D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X			D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X		D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
				X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
2	2	2	2	8	D2732-030	CUSHION
2	2	2	2	8	AN4-16A	BOLT

The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.

Qty -011	Qty -013	Part Number	Description
X		DSI-9459-011	Rubber Cushion Kit (for -121/-122/-123/-124 steps)
	X	DSI-9459-013	Rubber Cushion Kit (for -133 steps)
2	8	D2732-030	CUSHION
2	8	AN4-16A	BOLT






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CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.06.24
CERT. NO.: SH92-6
ISSUE NO.: 11

B	AN4-16A WAS -17A FOR -013/-133 KIT	CP	09.06.24
A	NEW ISSUE	CP	09.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9459	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OPTIONAL CLAMP MODIFICATIONS	NTS
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